

Work Order ID 87984 - 2

July-20-12 2:42:21 PM

87984

Page 1

Item ID: D4275-1

Revision ID:

Item Name: Fwd Beam

Start Date: 20/07/2012 Start Qty: 6.00

Required Date: 03/08/2012 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: MLJ

QC:

Date: 12/07/20 Tooling:

Date: SPC (Y/N):

N9000040100

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe.	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4275

A

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank to 39.750"

Batch: 1123321

1113455

11208600

0.00

0.00

110

110

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB006

DWG REV: A

FOLIO REV: 4A

0.00

0.00

2- deburr rough edges

12/08/01

12/24 12.8.2

Work Order ID 87984

July-20-12 2:42:21 PM

87984

Page 2

Item ID: D4275-1

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Beam

Start Date: 20/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/08/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

OK 12/08/02

9

8

PKO

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

Memo

0.00

SL 12-08-05

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

Memo

0.00

9

12-88

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: ASH Date: 12/08/13QA Closed: ASD Date: 12/08/14

Work Order: <u>87984-2</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>4275-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>12-1084</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	12/08/03	# 100	X	set-up requires a 1/4" shim. This information is not in the folio.	057012 12/06/09	• scrap + replace • correct folio.	24 12-8-3	 12/06/09	 057012 12/08/07
Equip/Tooling									
Operator									
Material									
Setup									
Other <input checked="" type="checkbox"/>									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

\$ 193.23

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input checked="" type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 87984

87984

Page 3

July-20-12 2:42:21 PM

Item ID: D4275-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fwd Beam

Stop *NS2*

Start Date: 20/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/08/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Disp.
Stamp

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

145

Powdercoat

Memo

0.00

Powder Coating

MASK AS PER DWG

S-10h40

T-320°F

F-11h10

m121481

9 x 2 12/08/08

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

9x 6 12/08/08

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

0.00

Packaging

9x 12-8-9

Work Order ID 87984

July-20-12 2:42:21 PM

87984

Page 4

Item ID: D4275-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Beam

Stop ***NS2***

Start Date: 20/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/08/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

12/8/9 

1208-9

Picklist Print

July-20-12 2:42:25 PM

Page 1

Work Order ID: 87984

87984

Parent Item: D4275-1

D4275-1

Parent Item Name: Fwd Beam

Start Date: 20/07/2012

Required Date: 03/08/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD
rev:B 10.12.02 AS PER DWG REV.A DD verf:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.000X04.00
0

Purchased

No

100

f

91.7185

3.3125

20.92105

36.67325

M6061T6B1 000X04 000

**

ET 12-08-10

6061-T6 Bar 1.00 x 4.00

Location

Loc Qty

Loc Code

MAT064

91.71845

116808

0.787

3 → 118400

13.48575

119346

0.1264

120243

1.57

120603

1.9435

3 → 120866

12

121380

25.8058

121836

12

4 → 12521

24

13.48575

99375

3.313

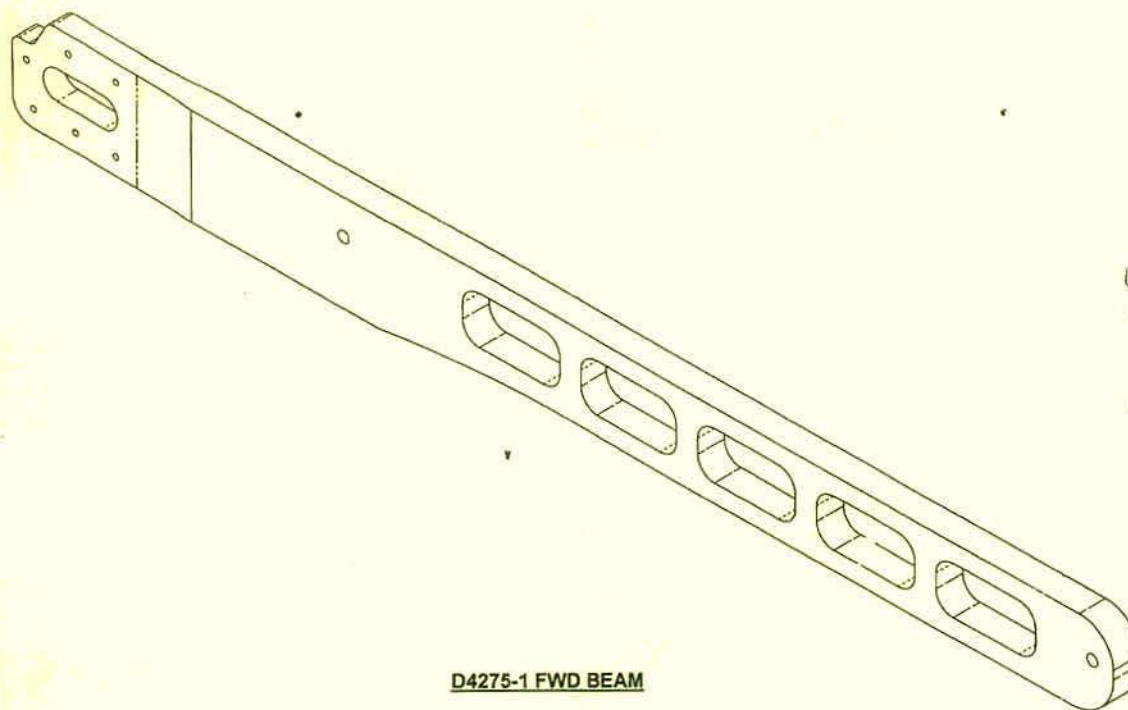
13.25

DART AEROSPACE LTD		Work Order:	8798Y
Description: Fwd Beam		Part Number:	D4275-1
Inspection Dwg: D4275	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.75	/			
26.700	+/-0.010	26.7	/			
Ø0.381	+0.000/-0.001	.381	/			
8.280	+/-0.010	8.280	/			
1.44	+/-0.030	1.44	/			
0.95	+/-0.030	.95	/			
3.50	+/-0.030	3.50	/			
13.28	+/-0.030	13.28	/			
13.50	+/-0.030	13.5	/			
9.25	+/-0.030	9.25	/			
5.00	+/-0.030	5.0	/			
0.75	+/-0.030	.75	/			
2.75	+/-0.030	2.75	/			
3.00	+/-0.030	3.00	/			
1.250	+/-0.010	1.250	/			
4.50	+/-0.030	4.50	/			
0.734	+/-0.010	.735	/			
0.108	+/-0.010	.108	/			
39.48	+/-0.030	39.48	/			
0.95	+/-0.030	.950	/			
0.60	+/-0.030	.60	/			
1.750	+/-0.010	1.750	/			
2.700	+/-0.010	2.700	/			
1.10	+/-0.030	1.10	/			
1.25	+/-0.030	1.250	/			
0.900	+/-0.010	.900	/			
0.75	+/-0.030	.750	/			
0.250	+/-0.010	.250	/			
3.000	+/-0.010	3.000	/			
1.500	+/-0.010	1.500	/			
Ø0.191	+0.005/-0.001	.191	/			

$$\frac{1}{\Gamma(\alpha)} \int_0^t (t-\tau)^{\alpha-1} \phi(\tau) d\tau = \phi(t) - \phi(0) + \int_0^t \phi(\tau) d\tau$$
[illegible]



D4275-1 FWD BEAM

SHIP COPY
 RETURNED TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 87984 MCT
 12/07/20

RELEASED
 2010-11-30
 MCT

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A		NEW ISSUE		SC	10.11.25
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED	#	DRAWING NO.	REV. A		
MFG. APPR.	#	D4275	SHEET 1 OF 2		
APPROVED	#	TITLE	SCALE		
DE APPR.	#	FWD BEAM	NTS		
DATE	10.11.25		<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>		

